

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020256**Date Inspected:** 05-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Liu Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG/TOWER**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

BAY 11, OBG BIKE PATH (NWIT # 06860)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004A1-021-043, 044 GREEN TAG NO. 14336

BK4ASD1-021-005, 006, 018, 021

BAY 11, OBG BIKE PATH (NWIT # 06862)

This QA inspector performed Ultrasonic Testing of approximately 10% Of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector has generated UT report for this date. The member(s) are identified as OBG components. The weld designations reviewed are as follows:

BK004C1-024-009

# WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

BK005A1-003-009

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY 10

SMAW welding of weld joint 044 located on BK004A1-028.

Welders are identified as 057258, 056364 & 052930. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2214-B-U2.

BAY 11, OBG BIKE PATH

FCAW welding of weld joint 044 located on BK005B1-004.

Welder is identified as 040723. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-P-2231-B-U2-F.

FCAW welding of weld joint 017 located on BK004A5-022.

Welder is identified as 066746. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

FCAW welding of weld joint 077 located on BK004A5-022.

Welder is identified as 066138. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) member identified as BK005B-004.

Distortion appeared to be caused by welding of the material. ZPMC Quality Control (QC) inspector identified as Mr. Shao Hai Lang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) number 9550.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



---

## WELDING INSPECTION REPORT

( Continued Page 3 of 3 )

---

### Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

---

<b>Inspected By:</b>	Gaikwad,Umesh
----------------------	---------------

Quality Assurance Inspector
-----------------------------

---

<b>Reviewed By:</b>	Carreon,Albert
---------------------	----------------

QA Reviewer
-------------